
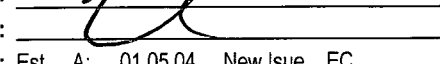


Date: Tuesday, 7/8/2008 7:07:19 AM
 User: Chantal Lavoie

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE BILLET
Job Number :	40350		
Estimate Number :	10036		
P.O. Number :		Part Number :	D6101013
This Issue :	7/8/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D6101 REV A
First Issue :	/ /	Project Number :	N/A
Previous Run :	38696	Drawing Revision :	A
Written By :		Material :	
Checked & Approved By :		Due Date :	7/23/2008
Comment :	Est. A: 01.05.04 New Issue EC		

Qty: 30 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 6712

C208107/08

a) Description: Aluminum billet

b) 10.100" x 8.250" x 2.50" thick (+0.030 / -0.000)

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Grain direction along 10.100" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

(30)

2.0	D6101013P	Saddle billet
-----	-----------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)
 Saddle billet

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

8/2/31 (34)

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6101

8/2/08/01 (+30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/8/2008 7:07:19 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET

Job Number: 40350

Part Number: D6101013

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

[Handwritten signature]

2/12

08/08/07

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

12/08/08

mf 08-08-05

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

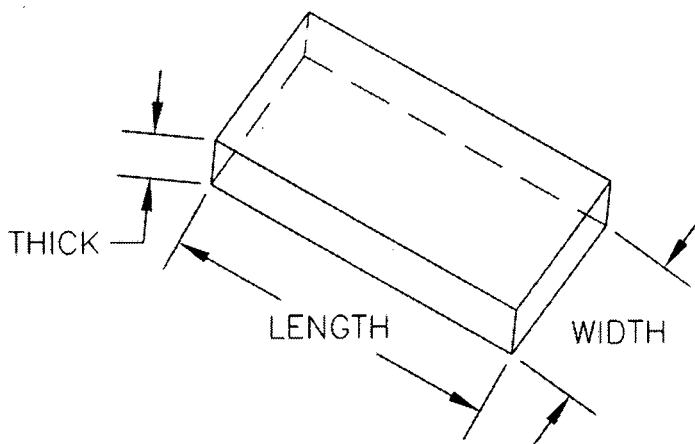
NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED [Signature]	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 [Signature]



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. _____

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

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O. REQUISITION CLIENT-CUSTOMER REQUISITION NO.

NO. COM. CLIENT-CUST. ORD. NO.

COMPTÉ-ACCT.

VEND.-SLS

TERR.

EXPÉDIE PAR-SHIP VIA

EXPÉDIE 29 JUL 2008

CHETEUR-PURCHASING AGENT

TELEPHONE

H/C

TAXE

NO. COM. ORD.

REGION LIVRAISON-DEL. ZONE

F.A.B.-F.O.B.

BILL

NO. FEVILLE/EMBALLAGE-BA

VRÉ A-SHIP TO:

VENDU A-SOLD TO:

INFORMATION CRÉDIT-CREDIT INFORMATION

ROUTE

INSTRUCTIONS/LIVRAISON-DELIVERY

INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)

INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)

DESCRIPTION - ITEM 1

2.5000 PLATE 7075-T7351 ALUM 8.25" X 10.10"

BLACK W/RED STRIPE

QTE/UNITE COM.-ORDERED

POES/PO COM.-ORD.

POIDS COM.-WT. ORDERED

CERTIFICATE OF CONFORMANCE

INSTRUCTIONS

COULÉE INFO-HEAT INFO

QTE-QTY

BALLOTS-BUNDLES

PCES/PO EXP. SHP.

POIDS EXP.-WT. SHIPPED

A.M. Castle & Co. certifies that the material(s) supplied under this document will meet and conform to the specifications of the product(s) described hereon.

A.M. Castle & Co. (Canada) Inc.

WEIGHT FOR SHIPPING PURPOSES ONLY. SEE INVOICES FOR ACCURATE BILLING WEIGHT. PLEASE SIGN AND DATE DRIVER'S COPY FOR RECEIPT OF MATERIAL AND, IF CHECKED, TEST REPORTS.

GRAIN TO RUN ALONG 10.10"

THICKNESS TOL.: +.030"/-.000"

TOL.: +.030"/-.000"

PRIOR DIST/ORD: 01 617305

30 x 8.25" x 10.10"

FORME-SHAPE

I.A.C.

ENT.-WT.

TERMS AND CONDITIONS OF SALE

SEE DISCLAIMERS AND LIMITATIONS ON THE REVERSE SIDE

INSTRUCTIONS

COULÉE INFO-HEAT INFO

QTE-QTY

BALLOTS-BUNDLES

PCES/PO EXP. SHP.

POIDS EXP.-WT. SHIPPED

DESCRIPTION - ITEM 2

1 SKID

INSTRUCTIONS (CONT'D.)

ENT.-WH.

ALL EXCEPTIONS FOR SHORTAGE OR DAMAGE MUST BE NOTED ON THE DRIVER COPY & CUSTOMER COPY OF THE DELIVERY RECEIPTS & SIGNED BY THE DRIVER & CUSTOMER. COPY OF SUCH RECEIPT PROPERLY NOTED MUST BE SUBMITTED WITHIN 10 DAYS WHEN CREDIT IS REQUESTED.

INSTRUCTIONS

COULÉE INFO-HEAT INFO

QTE-QTY

BALLOTS-BUNDLES

PCES/PO EXP. SHP.

POIDS EXP.-WT. SHIPPED

FORM (LETRE MOULÉE)-NAME (PRINT ONLY)

DATE REC'D

DATE RECEIVED

INSTRUCTIONS (CONT'D.)

ENT.-WHS

SHIP TO: A M CASTLE & CO 3400 NO. WOLF ROAD FRANKLIN PARK, IL 60131
SOLD TO: AM CASTLE & CO 3400 NO. WOLF ROAD FRANKLIN PARK, IL 60131

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
 Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
 4122744

CUSTOMER PO NUMBER: 01-42198		WORK PACKAGE:		CUSTOMER PART NUMBER: 6879 A97075-60		SHIP RUNLOAD ID: 101230/11		GOV'T CONTRACT NUMBER:	
KAISER ORDER NO: 1061904	LINE ITEM: 1	SHIP DATE: 28-FEB-2008	ALLOY: 7075	CLAD: BARE	TEMPER: T7351	PRODUCT DESCRIPTION: MILL FINISH PLATE			
WEIGHT SHIPPED: 3596 LB.	QUANTITY: 2 PCS EST.	B/L NUMBER: 2016662		GAUGE: 2.5000 IN		WIDTH: 48.500 IN		LENGTH: 144.500 IN	

Certified Specifications

AMS 4078/RevG
 ASTM B 209/Rev07
 BSS 7055/RevA
 DPS 4.713/RevAH
 GSS16100/RevG

AMS-QQ-A-250/12
 ASTM B 594/Rev06
 CMMP 025/RevR
 EAC MS1011/RevE
 MMS 159/RevN

AMS-STD-2154
 BAC 5438/RevH
 CSTI 006/RevC
 GAMPs 9101/RevB
 PS 21211/RevK

Test Code: 4287

Test Results

Lot: 436539A1 Cast 149

Drop 39

Ingot 4

(ASTM B209)

Tensile: Temper
 T7351

Dir / # Tests
 LT / 2 (Min:Max)

Ultimate KSI (MPA)
 71.0 : 71.5
 (490 : 493)

Yield KSI (MPA)
 59.6 : 61.2
 (411 : 422)

Elongation %
 10.3 : 10.6

(ASTM E1004)

Conductivity %IACS :
 (MS/M) :

41.1 Min
 23.8 Min

41.5 Max
 24.1 Max

(ASTM E1251)

Chemistry:
 Actual

SI FE CU MN MG CR ZN TI V ZR

0.10 0.22 1.5 0.02 2.5 0.20 5.7 0.03 0.01 0.01

0.03 0.01 0.01

0.03 0.01 0.01

0.03 0.01 0.01

OTHER
 TOT 0.03

CASTLE METALS CORP.

DATE RCVD 3/4/08

IAC 6879

APPROVED BY

**KAISER
ALUMINUM**Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586**CERTIFIED TEST REPORT**Serial Number
4122744

Lot: 436673A8 Cast 149

Drop 38

Ingot 3

(ASTM B557)

Tensile:

Temper

Dir / # Tests

LT / 2 (Min:Max)

Ultimate KSI (MPA)

71.0 : 71.3

(490 : 492)

Yield KSI (MPA)

59.8 : 60.0

(412 : 414)

Elongation %

10.4 : 10.4

(ASTM E1004)

Conductivity %IACS :

(MS/M) :

41.0 Min

23.8 Min

41.2 Max

23.9 Max

(ASTM E1251)

Chemistry:

Actual

SI

FE

CU

MN

MG

CR

ZN

TI

V

ZR

TOT

OTHER
0.03**ALLOY LIMITS**

Chemistry:

7075 MIN

MAX

SI

FE

CU

MN

MG

CR

ZN

TI

V

ZR

OTHER
EACH
TOTMAX
0.05
0.15**Aluminum Remainder****TEST NOTES**

Metal represented by this test report was immersion
ultrasonically tested from one side and meets the Class A
and Class B requirements of all specifications referenced
on this test report.

CERTIFICATION

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED IN THE U.S.A OR CANADA AND
MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS
INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD
GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL,
WITHOUT THE WRITTEN APPROVAL OF ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS
OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW, 18U-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR

